



Fermilab

Fermi National Accelerator Laboratory

Technical Division-Machine Shop

Welder Performance Qualification Record

Date
12/23/2008

Revision: 2 Revision Date: 6/17/2009 Remarks: Add range qualified

In accordance with Fermi WPS Ti-3

Welders Name: Michael Reynolds Fermi ID# 03993N Weld Stamp # 9
WPS Number: Fermi WPS Ti-3 Test Coupon Production Weld N/A
Welding Process/Type: GTAW/Orbital/Automatic—AMI Orbital Machine Model 227-STD1.9
Type of Joint Welded: Pipe Groove Weld Joint Types Qualified: Groove and Fillet/Lap Weld
Base Metals Welded: SB-861, Grade 2 to SB-861, Grade 2

Welder Variables (QW-350)	Actual Variables Used	Range Qualified
AWS Classification:	ERTi-2	
Filler Metal Specification (SFA)		
Filler Metal F-No.		
Filler Metal Product Form		
Consumable Insert	No Insert Used	
P- or S- Number to P- or S- Number:	P-No. 51	
Base Metal Thickness (inches):	0.078"	
Pipe Diameter (inches):	3"	
Deposit Thickness (inches)	0.197"	
Welding Position/Progression	5G	
Backing Gas	Argon Backing Gas Used	
GTAW-Current/Polarity	DCEN	

Qualified to weld
any Qualified
Automatic GTAW
WPS

Machine Welding Variables (QW-360)	Actual Variables	Range Qualified
Direct/Remote Visual Control	N/A	N/A
Automatic Voltage Control	N/A	N/A
Automatic Joint Tracking	N/A	N/A
Welding Position	N/A	N/A
Consumable Insert	N/A	N/A
Backing	N/A	N/A
Single/Multiple Pass Per Side	N/A	N/A

Fillet/Lap Welds: All

Guided Bend Test (QW-160)	Face Bend #1-Acceptable Face Bend #2-Acceptable	Root Bend #1-Acceptable Root Bend #2-Acceptable	Test Number 1215-008/02
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Visual examination results: Visual exam satisfactory per QW-302.4 and QW-194

Radiographic test results: N/A

Mechanical tests conducted by: Bodycote Testing Group

Welding Test conducted by: Fermi National Accelerator Laboratory Verification Number 12808-01RH

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Fermi National Accelerator Laboratory

Roger Hiller
Authorized Representative

00362N

6/17/09
Date